

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023764**Date Inspected:** 19-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Liu Huajie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

Trial Assembly:-

Flux Cored Arc (FCAW) welding of Weld Joint SEG3011A-003&SEG3019A-001(13CE+14AE Bottom panel to Side Panel weld, CB Side), and Welder is identified as 066763; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu, The welding variables appeared to comply with the Applicable WPS-B-P-2231-ESAB.

Shielded Metal Arc (SMAW) welding of Weld Joint BP3045-001-049~060&BP3082-001-001~012(13CE+14AE Bottom panel I Rib Hold back weld), and Welder is identified as 070007; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu, The welding variables appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

Flux Cored Arc (FCAW) welding of Weld Joint SA6502-001-003,004(12CE weld), and Welder is identified as 040432; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu, The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Flux Cored Arc (FCAW) welding of Weld Joint SA6503-001-001,002(12CE weld), and Welder is identified as 057266; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu, The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Flux Cored Arc (FCAW) welding of Weld Joint SA6516-001-001~004(12CE weld), and Welder is identified as 204868; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu, The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3007-001(13AE Deck panel Splice Weld), and Critical Welding Repair Report (CWR) B-CWR2925 Rev.1, Welder is identified as 066416; ZPMC Quality Control (QC) is identified as Mr. Shi Lei, The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3007J-013(13AE Deck panel to Deck Panel Diaphragm weld, BK Side), and Welding Repair Report (WR) B-WR20872, Welder is identified as 043661; ZPMC Quality Control (QC) is identified as Mr. Li Huajie, The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Flux Cored Arc (FCAW) welding of Weld Joint SA3020-001-003,006(13AE Edge panel I Rib weld, CB Side, PP117.5~118), and Welder is identified as 067184; ZPMC Quality Control (QC) is identified as Mr. Li Huajie, The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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| Inspected By: | Tharikoppada,Reddy | Quality Assurance Inspector |
| Reviewed By: | Miller,Mark | QA Reviewer |
